

Shp Jan 17

Work Order ID 95525

\*95525\*

Page 1

January-10-13 3:09:55 PM

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Hinge, Door LH Lower

Start Date: 1/10/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/16/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3957

A

100

0.00

\*100\*

Bandsaw

Jeaspa Bandsaw

Memo

cut blank to 3.200" long

0.00

13/01/11

4

0

110

0.00

\*110\*

HAAS I

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA839

FOLIO REV: AA

DWG REV: A

0.00

B.A 13/01/13

4

0

DAS  
08  
9-83

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

**\*95525\***

January-10-13 3:09:55 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 1/10/13      **Start Qty:** 4.00      **\*4\***

**Cust Item ID:**

**Required Date:** 1/16/13      **Req'd Qty:** 4.00      **\*^\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

# Work Order ID 95525

\*95525\*

Page 3

January-10-13 3:09:55 PM

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Hinge, Door LH Lower

Start Date: 1/10/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/16/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Adjust

0.00

\*150\*

Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location

0.00

\*170\*

Packaging

Memo

0.00

Packaging

4 0 BL 13-1-15

4 x 1 13-1-15

4x SP 13-01-15

**Work Order ID 95525****\*95525\***

Page 4

January-10-13 3:09:55 PM

Item ID: D3957-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Hinge, Door LH Lower

Start Date: 1/10/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/16/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 13-01-15

MF  
13-1-15

# Picklist Print

January-10-13 3:09:55 PM

Page 1

Work Order ID: 95525

Parent Item: D3957-3

Start Date: 1/10/13

Required Date: 1/16/13

Parent Item Name: Hinge, Door LH Lower

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X03.000 6061-T6 Bar .750 x 3.00		Purchased	No			100	f	20.5780	0.2666	1.1225263			

### Location

### Loc Qty

### Loc Code

MAT049

20.578

104741

20.494

15211

0.084

1.123 01/13/13/11

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45525
<b>Description:</b> Hinge, Door LH Lower		<b>Part Number:</b> D3957-3
<b>Inspection Dwg:</b> D3957	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

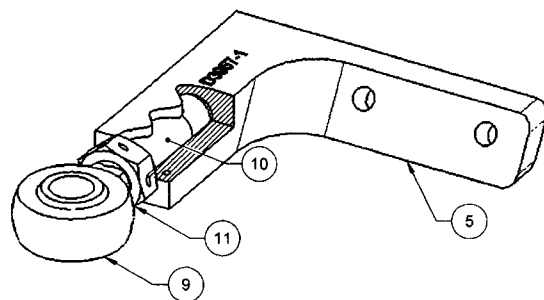
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	0.684	✓		Vern	GA-01
0.281	+/-0.010	0.277	✓		"	"
0.281	+/-0.010	0.281	✓		"	"
3.00	+/-0.030	3.000	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-G	ref.
0.563	+/-0.010	0.562	✓		Vern	GA-01
1.25	+/-0.030	1.260	✓		"	"
1.93	+/-0.030	1.944	✓		"	"
107°	+/-0.5°	107°	✓		Angle Meter	CNC-03
0.250	+/-0.010	0.255	✓		Vern	GA-01
Ø0.203	+0.005/-0.001	Ø0.204	✓		"	"
1.170	+/-0.010	1.170	✓		"	"
0.39	+/-0.030	0.378	✓		"	"
0.33	+/-0.030	0.330	✓		H-G	31006
Ø0.063	+0.004/-0.001	Ø0.065	✓		Vern	GA-01
0.125	+/-0.010	0.128	✓		H-G	31006
0.094	+/-0.010	0.094	✓		"	"
0.12	+/-0.030	0.150	✓		Vern	GA-01
R0.50	+/-0.030	R0.500	✓		R-G	ref.

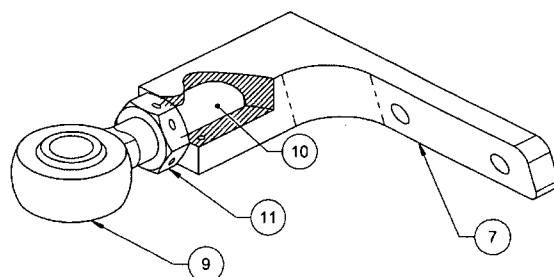
<b>Measured by:</b> b.a 08	<b>Audited by:</b> RA	<b>Prototype Approval:</b> N/A
<b>Date:</b> 13/01/13	<b>Date:</b> 13.1.14	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	09.11.13	New Issue	KJ	

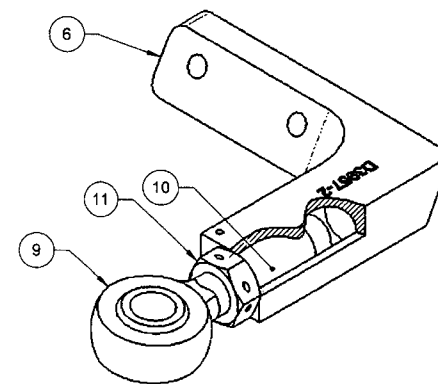
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



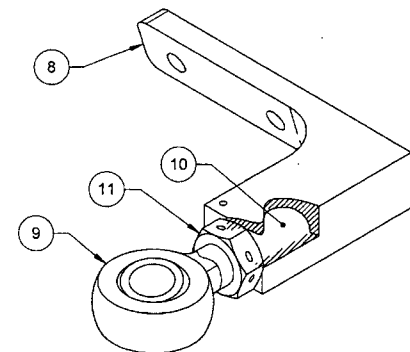
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**



**D3957-044 HINGE ASSY, DOOR RH LOWER**

**RELEASED**  
2009-10-08  
JMB

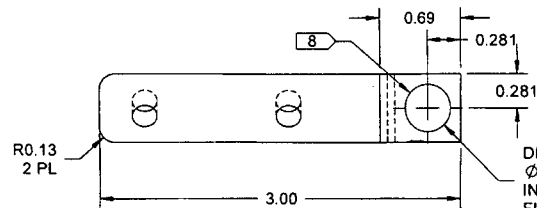
*W095525*

A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

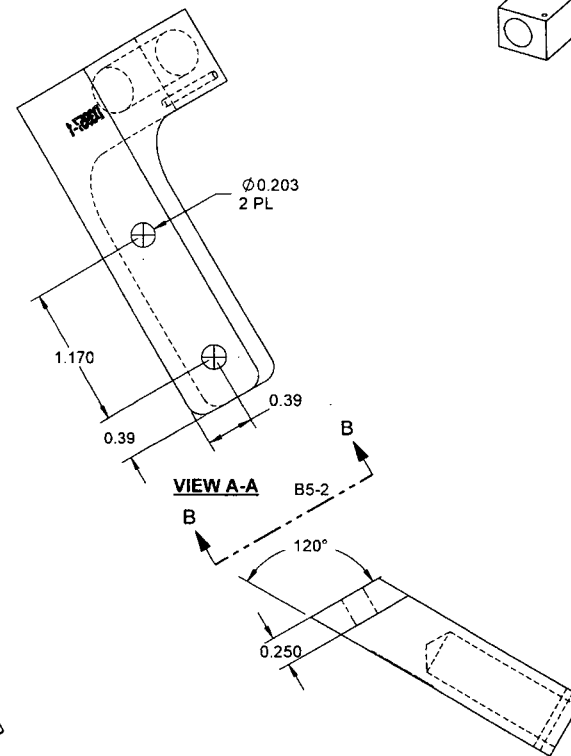
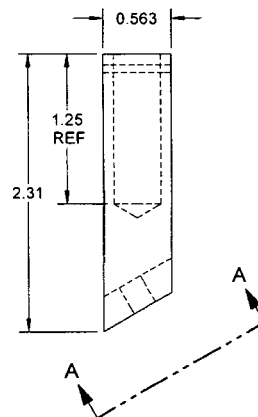
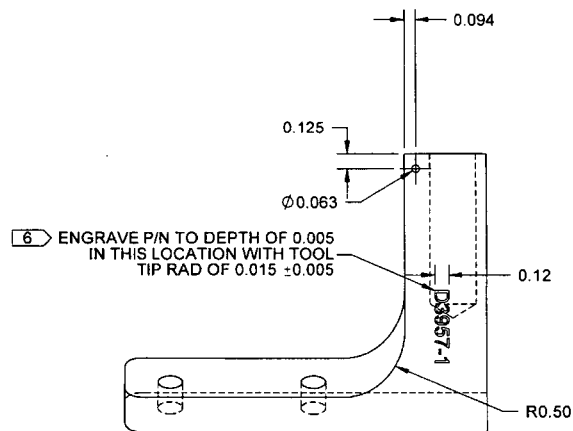
  

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A
TITLE HINGE	SHEET 1 OF 5
SCALE NTS	

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DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



VIEW B-B

D3957-1 HINGE, DOOR LH UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

C3-2

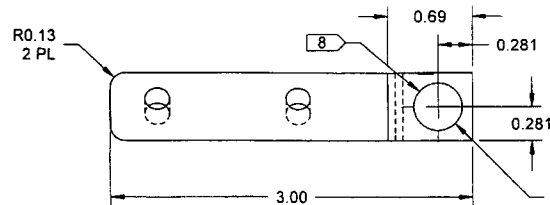
**RELEASE**  
 2009-10-08

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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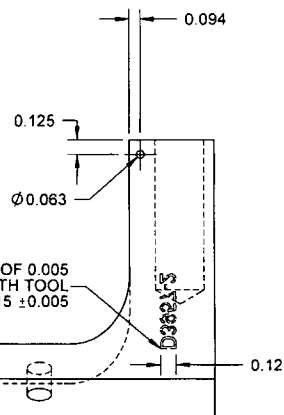
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D

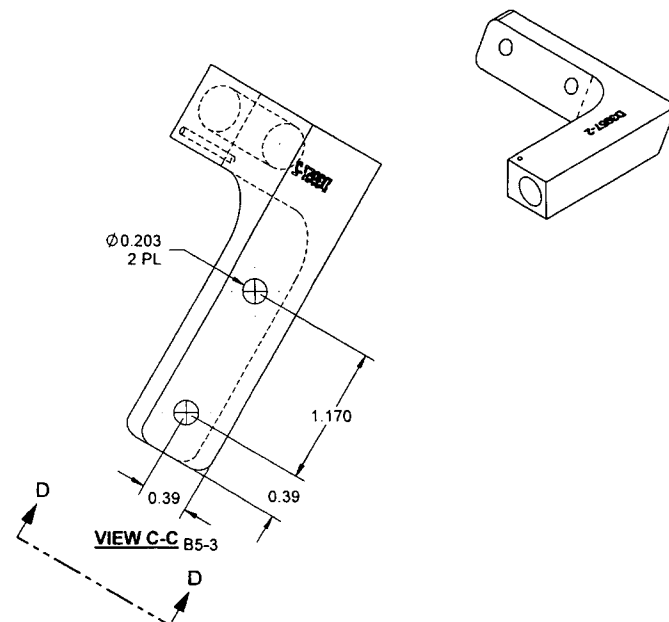
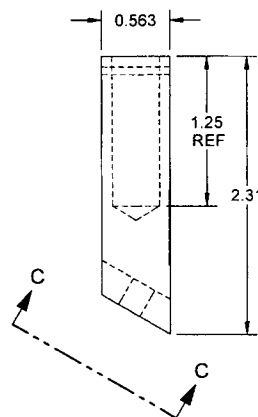


DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE

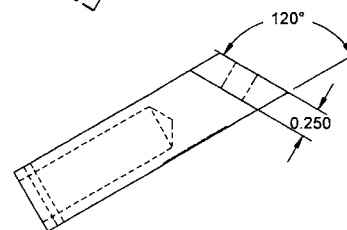
C



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm$  0.005



VIEW C-C  
 B5-3



VIEW D-D

C3-3

D3957-2 HINGE, DOOR RH UPPER

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**RELEASED**  
 2009-10-08

DESIGN	DE	<b>DART AEROSPACE LTD</b>	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	<b>D3957</b>	SHEET 3 OF 5
APPROVED	21	TITLE	SCALE
DE APPR.	21	<b>HINGE</b>	NTS
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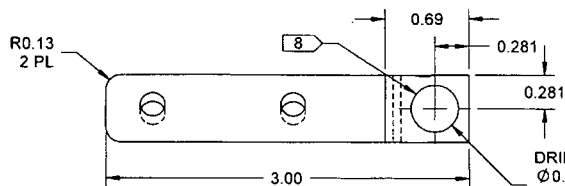
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D

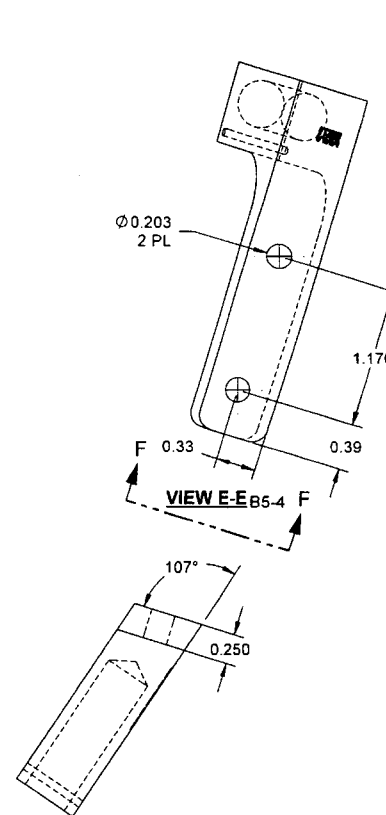
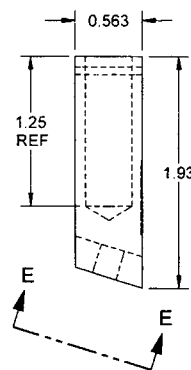
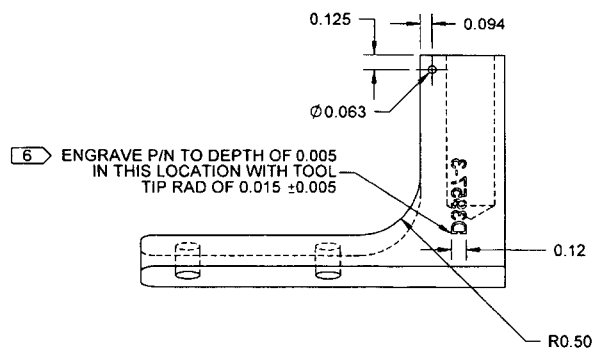
C

B

A



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
Ø 0.391 X 1.25 DP  
INSTALL HELICOIL MS124818  
FLUSH WITH SURFACE



VIEW F-F C3-4

**D3957-3 HINGE, DOOR LH LOWER**

**RELEASED**  
2009 -10- 08

**NOTES:**

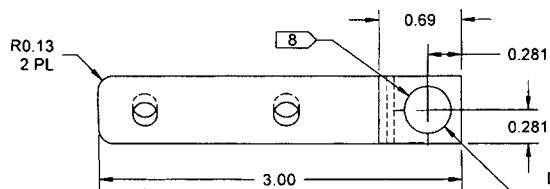
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 4 OF 5
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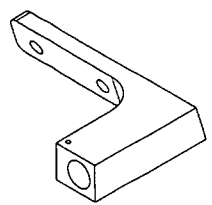
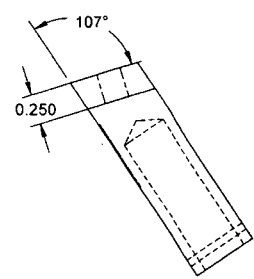
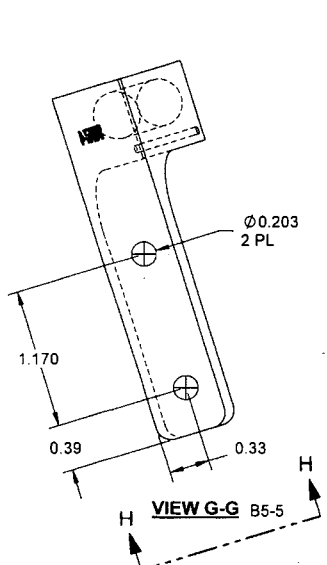
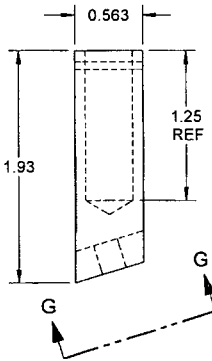
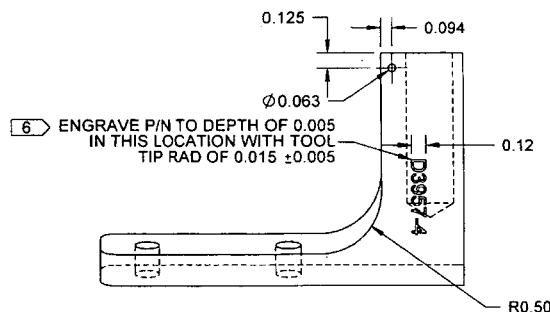
8 7 6 5 4 3 2 1

D



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE

C



D

C

B

**D3957-4 HINGE, DOOR RH LOWER**

VIEW H-H C3-5

**RELEASED**  
 2009-10-08  
*AWD*

- NOTES:**
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
  - 7) WEIGHT: 0.09 lbs
  - 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>AS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	<b>D3957</b>	SHEET 5 OF 5
APPROVED	<i>AS</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1